

Date: Thursday, 9/28/2006 3:55:36 PM  
 User: Kim Johnston

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : 350/355 AS X-TUBE AFT
<b>Job Number</b> : 28774	
<b>Estimate Number</b> : 12486	
<b>P.O. Number</b> : N/A	<b>Part Number</b> : D350748201
<b>This Issue</b> : 9/28/2006 <b>S.O. No.</b> : N/A	<b>Drawing Number</b> : IIN-D350-748 PG5
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : <i>N/A</i> <b>Type</b> : LANDING GEAR	<b>Drawing Revision</b> : A UNDER REVIEW <i>CP 06.10.03</i>
<b>Previous Run</b> : 28471	<b>Material</b> : N/A
<b>Written By</b> : <i>[Signature]</i>	<b>Due Date</b> : 11/20/2006 <b>Qty:</b> 1 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <i>[Signature] 06 10 03</i>	
<b>Comment</b> : Est Rev: A New Issue 06-07-05 JLM Est Rev: B Update qty of MS21042L5 06-09-12 KJ	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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①

**Comment:** Photocopy bluefile & type labels per PPPD350-748-201

CHG001 *CL**KS 06 10 23*

2.0	28774A	X-TUBE AS 350/355 HI AFT
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**Comment:** Sub-Component X-TUBE AS 350/355 HI AFT

D350-748-241 B *28774A*

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

Pick Packing Kit

4.0	D35001	350 SADDLE
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**Comment:** Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

350 SADDLE

Batch: *B28477* ✓

5.0	D35011	BUSHING
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**Comment:** Qty.: 16.0000 Each(s)/Unit Total: 16.0000 Each(s)

BUSHING

Batch: *B29799* ✓

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 9/28/2006 3:55:37 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350/355 AS X-TUBE AFT

Job Number: 28774

Part Number: D350748201

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

AN46A

Bolt



Comment: Qty.: 16.0000 Each(s)/Unit Total : 16.0000 Each(s)

Bolt

Batch: M102115 ✓

7.0

AN441A

bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

bolt

Batch: M101538 ✓

8.0

AN532A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: M103338 ✓

9.0

AN960JD416

Washer



Comment: Qty.: 32.0000 Each(s)/Unit Total : 32.0000 Each(s)

Washer

Batch: M102929 ✓

10.0

AN960JD516

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Washer

Batch: M102519 ✓

11.0

MS21042L4

Nut



Comment: Qty.: 24.0000 Each(s)/Unit Total : 24.0000 Each(s)

Nut

Batch: M103914 ✓

12.0

MS21042L5

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Batch: M100564 ✓

*[Handwritten Signature]*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ ☐ Date: 07/04/12  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 9/28/2006 3:55:37 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350/355 AS X-TUBE AFT

Job Number: 28774

Part Number: D350748201

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



207/04/11 ①

Comment: INSPECT 100% KITS FOR COMPLETENESS

*7/4/11* ①

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-748-201

Location:

PPP Rev:

*DRAFT*

*7/4/11* ①

15.0

QC21

FINAL INSPECTION/W/O RELEASE

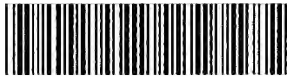


①

Comment: FINAL INSPECTION/W/O RELEASE

*207/04/12*

Job Completion



*207/04/11*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

3.10 Apply a continuous bead of Sikaflex-241/-291 or Proseal 890 or MIL-S-8802 Class B2 sealant in the following locations as per Figure 6:

- A) Along saddle/crosstube interface.
- B) Between the saddle flanges.
- C) Along saddle/skidtube interface.

#### 4.0 WEIGHT AND BALANCE

The following weight and balance information is for Dart crosstube installations only. This data should be similar to the existing installation. Differences from the parts removed are the responsibility of the installer.

DART CROSSTUBE	FWD/AFT	WEIGHT	STA	MOMENT
D350-748-101	Fwd	35.2 lb (16.0 kg)	106.3 in (2.70 m)	3742 lb-in (43.2 kg-m)
D350-748-201	Aft	34.7 lb (15.7 kg)	162.4 in (4.12 m)	5635 lb-in (64.7 kg-m)

#### 5.0 PARTS LIST

Qty -101	Qty -201	Part Number	Description
X		D350-748-101	CROSSTUBE INSTALLATION, AS 350/355 HIGH FWD
	X	D350-748-201	CROSSTUBE INSTALLATION, AS 350/355 HIGH AFT
1		D350-748-141	CROSSTUBE ASSEMBLY, AS 350/355 HIGH FWD
	1	D350-748-241	CROSSTUBE ASSEMBLY, AS 350/355 HIGH AFT
*2	*2	D3502-1	SUPPORT
*2	*2	D2856-400-710	ABRASION STRIP
*1	*1	AELS-1032-225	INSERT
*2	*2	MS21920-20	CLAMP
*1	*1	MS27039-1-10	SCREW
*1	*1	AN960JD10	WASHER
4	4	D3500-1	SADDLE
16	16	D3501-1	BUSHING
16	16	AN4-6A	BOLT
8	8	AN4-41A	BOLT
4	4	AN5-32A	BOLT
32	32	AN960JD416	WASHER
8	8	AN960JD516	WASHER
24	24	MS21042L4	NUT (OR MS21042-4)
4	4	MS21042L5	NUT (OR MS21042-5)

\* REFERENCE ONLY. PARTS ARE INCLUDED IN D350-748-141/241 ASSEMBLIES ABOVE

STOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 28774





Date: Thursday, 9/28/2006 3:55:54 PM  
 User: Kim Johnston

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : X-TUBE AS 350/355 HI AFT
<b>Job Number</b> : 28774A	
<b>Estimate Number</b> : 12483	
<b>P.O. Number</b> : N/A	<b>Part Number</b> : D350748241
<b>This Issue</b> : 9/28/2006 <b>S.O. No.</b> : N/A	<b>Drawing Number</b> : D350-748-241
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : N/A <b>Type</b> : LANDING GEAR	<b>Drawing Revision</b> : C UNDER REVIEW 06.10.03
<b>Previous Run</b> : 28471A	<b>Material</b> : N/A
<b>Written By</b> : _____	<b>Due Date</b> : 11/20/2006 <b>Qty:</b> 1 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>06 10 03</u>	
<b>Comment</b> : Est Rev: A New Issue 06-07-05 JLM Est Rev: B Update cadplate process 06-09-12 KJ	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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**Comment:** DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D350-748-241 CHG001

N/A

2.0	D6018125	Crosstube Material
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Crosstube Material

D6018-125

2.299" OD X 2.000" ID

Batch: 327472

06/10/04

1

3.0	MORI SEIKI	MORI SEIKI CNC LATHE LARGE
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**Comment:** MORI SEIKI CNC LATHE LARGE

1-Fill tube with sand &amp; install plugs on both ends as per Folio FA647

2-Turn first side as per Folio FA647

3-Deburr &amp; Inspect for surface damage. Repair damage within limits as per Dwg D350-748-241. M8 06/10/06 1

4.0	QC1	INSPECT ALL DIM TO DIM SHEET
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**Comment:** INSPECT ALL DIM TO DIM SHEET

M8 06/10/06 1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 9/28/2006 3:55:55 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: X-TUBE AS 350/355 HI AFT

Job Number: 28774A

Part Number: D350748241

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

MORI SEIKI

MORI SEIKI CNC LATHE LARGE



Comment: MORI SEIKI CNC LATHE LARGE

1-Turn second side as per Folio FA647

2-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D350-748-241.

3-Scribe part # as per Dwg D350-748-241

MS 06/10/06

6.0

QC1

INSPECT ALL DIM TO DIM SHEET



Comment: INSPECT ALL DIM TO DIM SHEET

MS 06/10/06

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK

BC 06-10-08

8.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

Remove all Machining Marks

PM 06-10-160

9.0

OUTSIDE SERVICE

OUTSIDE SERVICES



Comment: Sub-Contracting OUTSIDE SERVICES

Issue P/O: 2263

Heat Treat to min 180 KSI As per Dwg D350-748-241

Sand Blast tube after Heat Treat

Possible Supplier: Vac Aero

Ensure Certificate of Conformity is attached

CL 06/10/17

10.0

PACKAGING 1

PACKAGING RESOURCE #1



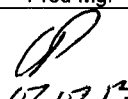
Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure certificate of conformity is attached

PB 06/11/30

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07.02.13	16	MAGNETIC PARTICLE INSPECT PER DART QSI 038 4.2 Cadmium Plate per AMS-QQ-P-416B, CLASS 1, TYPE II REF. D350-746-291 (Rev D)				 07.02.13 PC 451 442	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 9/28/2006 3:55:55 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: X-TUBE AS 350/355 HI AFT

Job Number: 28774A

Part Number: D350748241

Job Number:



Seq. #:

Machine Or Operation:

Description:

11.0

QC6

DIMENSIONAL CHECK



*206-12-04 ①*



Comment: DIMENSIONAL CHECK

12.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Oil inside of tube with LPS-3.

A/R

LPS-3

Batch:

*M101915*

*DP 6-12-6*

13.0

BENDING

BENDING MACHINE



Comment: BENDING MACHINE

Bend tube as per Dwg D350-748-241 using CNC bender program D350A and Folio FT

*DP 6-12-6*

14.0

QC6

DIMENSIONAL CHECK



*206-12-21 ①*



Comment: DIMENSIONAL CHECK

15.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Remove all marks from tube within limits of D350-748-241

2-Drill Tube as per Dwg D350-748-241 Using DT8876 Drill Jigs,  
Set-up drill table as per QSI 010

3-Deburr

4-Engrave Part # and Batch # as per Dwg D350-748-241

*206-12-27*

*DP 6-12-27*

16.0

OUTSIDE SERVICE

OUTSIDE SERVICES



Comment: Sub-Contracting OUTSIDE SERVICES

Issue P/O: *3206*

Stress relief at 375° for 5 hours

Magnetic Particle Inspect per ASTM E1444

Cadium Plate per QQ-P-416F, Class 1, Type 2

Embrittle relief at 375° for 8 hours, Chromate Treat

Possible Supplier: Southwest United Industries

Ensure Certificate of Conformity is attached

*CD 7/10/28 ①*  
POSITIVE RECALL

EFFECTIVE *06.10.03* AUTH *CP*

RELEASED *CP* DATE *07.02.13*

*SEE WORK ORDER CHANGE*

*REF. D350-748-241 REV.D*

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
070213	15-1	QCS Perm. Change					
		QCS	P070213	070213	1	070213	070213

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 9/28/2006 3:55:55 PM  
User: Kim Johaston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: X-TUBE AS 350/355 HI AFT

Job Number: 28774A

Part Number: D350748241

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure certificate of conformity is attached

12/3/28 ①

18.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

200.00 ①

19.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

1-Prime inside crosstube as per QSI 005 4.2

2-Paint Outside of Tube as per Dart QSI 005 4.2

7 mm 070409

①

20.0

QC14

Inspect Spray Paint



Comment: Inspect Spray Paint

Then, Wrap in plastic bag to protect from scratches

RT 07 04 10

21.0

D35021

SUPPORT



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

SUPPORT

Batch:

28476 RT 07-04-10

22.0

D2856400

Abrasion Strip



Comment: Qty.: 1.2401 f(s)/Unit Total: 1.2401 f(s)

Abrasion Strip 7.10" long x2

Batch:

29050 RT 07-04-10

23.0

ALS41032225

Insert



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Insert

Batch:

m19393 RT 07-04-10

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



Date: Thursday, 9/28/2006 3:55:55 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: X-TUBE AS 350/355 HI AFT

Job Number: 28774A

Part Number: D350748241

Job Number:



Seq. #:

Machine Or Operation:

Description :

24.0

AN960JD10

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Washer

Batch: 103641

BT 02-04-10

25.0

MS2192020

Clamp (per MIL-DTL-8783C)



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Clamp (per MIL-DTL-8783C)

Batch: 102440

BT 02-04-10

26.0

MS27039110

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Screw

Batch: 18836

BT 02-04-10

27.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install Ground wire Insert, then insert screw and washer

2-Install Abrasion strips as per Dwg D350-748-241 & QSI 035.

3-Install supports Using Dt8876 as per Dwg D350-748-241, Torque to 60-80 IN-LBS

BT 02-04-10

28.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

DP 2-4-11

29.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-748-241

Location: \_\_\_\_\_

PPP Rev: \_\_\_\_\_

PPP B28774 C-2/4/11 (1)

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: ☒ Date: 21/04/10  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 9/28/2006 3:55:55 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: X-TUBE AS 350/355 HI AFT

Job Number: 28774A

Part Number: D350748241

Job Number:



Seq. #:

Machine Or Operation:

Description :

30.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

10/2/04/12 (1)

Job Completion



U of A 11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>QP</i>	DRAWN BY <i>QP</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D350-748-241	REV. C SHEET 1 OF 3
DATE 06.08.14		TITLE CROSSTUBE (AS 350/355 HI AFT)	SCALE NTS
A	06.03.31	NEW ISSUE	
B	06.06.30	ADD D6018-125 & PRIME AND PAINT	
C	06.08.14	ADD CAD PLATING	

**UNDER REVIEW**

*UP 06.08.14*  
CAD PARTIAL PROCEDURE  
WAS & PRIME

QTY	P/N	DESCRIPTION
X	D350-748-241	CROSSTUBE ASSEMBLY (AS 350/355 HI AFT)
1	D6018-125	CROSSTUBE (OR D6015-125)
2	D3502-1	SUPPORT
2	D2856-400-710	ABRASION STRIP
1	AELS-1032-225	INSERT
1	AN960JD10	WASHER
2	MS21920-20	CLAMP (PER DART SPEC/M-MS21920-20)
1	MS27039-1-10	SCREW

**D350-748-141 CROSSTUBE:**

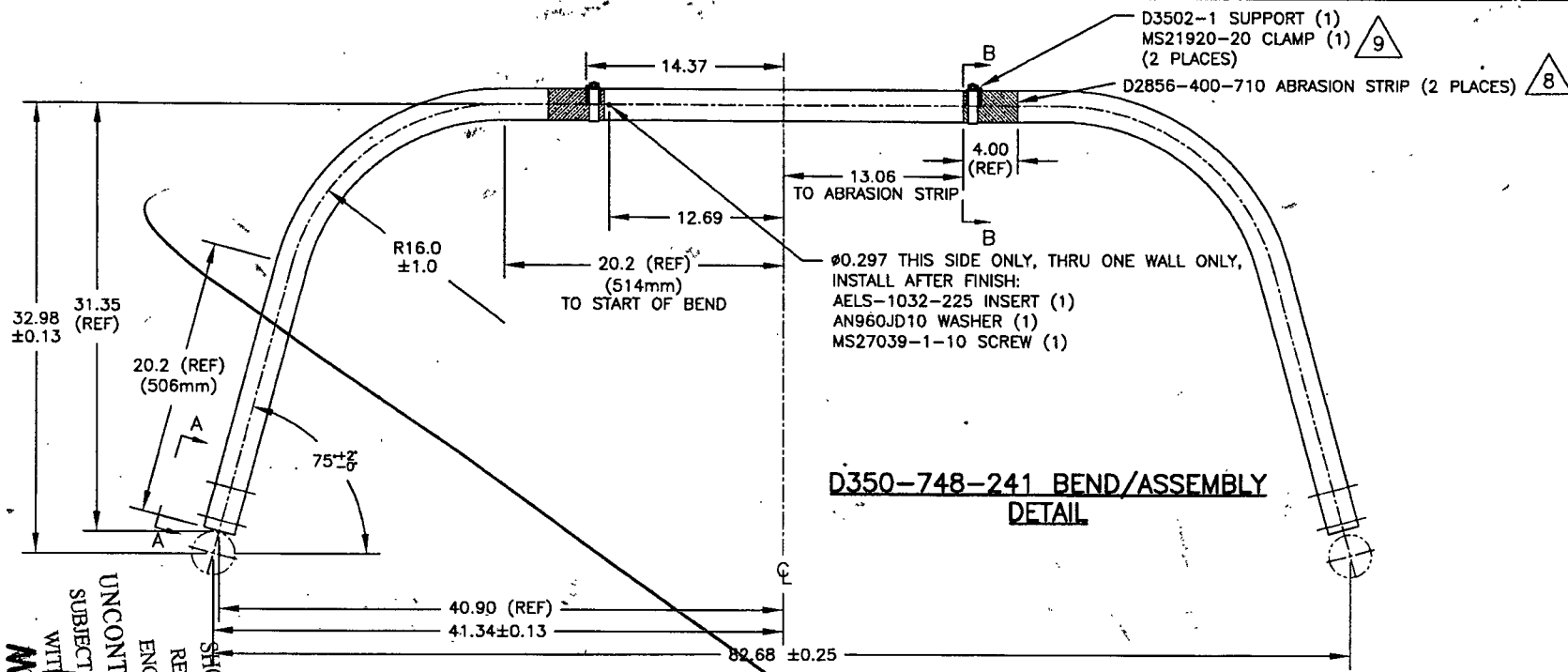
- 1) MATERIAL: MANUFACTURED FROM D6018-125 OR D6015-125  
FINISHED LENGTH = 122.70±0.06
- 2) MACHINE PER MACHINING DETAIL ON PAGE 3. BLEND OUT ALL EDGES FROM MACHINING LONGITUDINALLY, TRANSITIONS SHOULD BE SMOOTH. NOTE: ALL HOLES ARE DRILLED AFTER BENDING.
- 3) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 4) BEND PROGRESSIVELY WITH A MINIMUM OF 7 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 5) HEAT TREAT TO MIN. 180 KSI PER MIL-T-6736 OR AMS 2759-1C AFTER TURNING
- 6) FINISH: CADMIUM PLATE PER QQ-P-416F, CLASS 1, TYPE II  
MAGNETIC PARTICLE INSPECT PER ASTM E1444 AFTER CADMIUM PLATING  
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2  
PAINT OUTSIDE PER DART QSI 005 4.2
- 7) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE. WHEN DRILLING HOLES EXTREME CARE MUST BE TAKEN AND CAREFUL DEBURRING PERFORMED TO ENSURE A CLEAN HOLE WITH NO CRACKING/CHIPPING/GROOVES.
- 8) INSTALL D2856-400-710 ABRASION STRIP WITH A GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D3502-1 SUPPORT, PER QSI 035.
- 9) TORQUE MS21920-20 CLAMPS 60 TO 80 IN-LB
- 10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 11) ALL DIMENSIONS ARE IN INCHES
- 12) PART IS SYMMETRIC ABOUT CENTERLINE EXCEPT FOR Ø0.297 HOLE.

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06.08.15 *#*

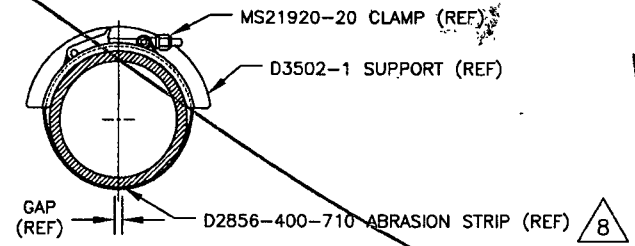
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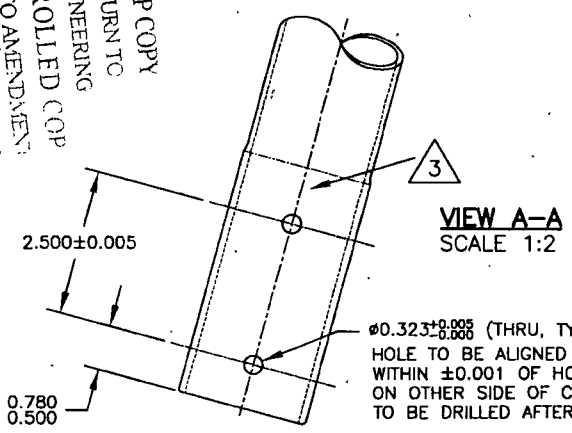


**D350-748-241 BEND/ASSEMBLY  
DETAIL**

**SECTION B-B  
SCALE 1:2**



**RELEASED**  
06.08.15

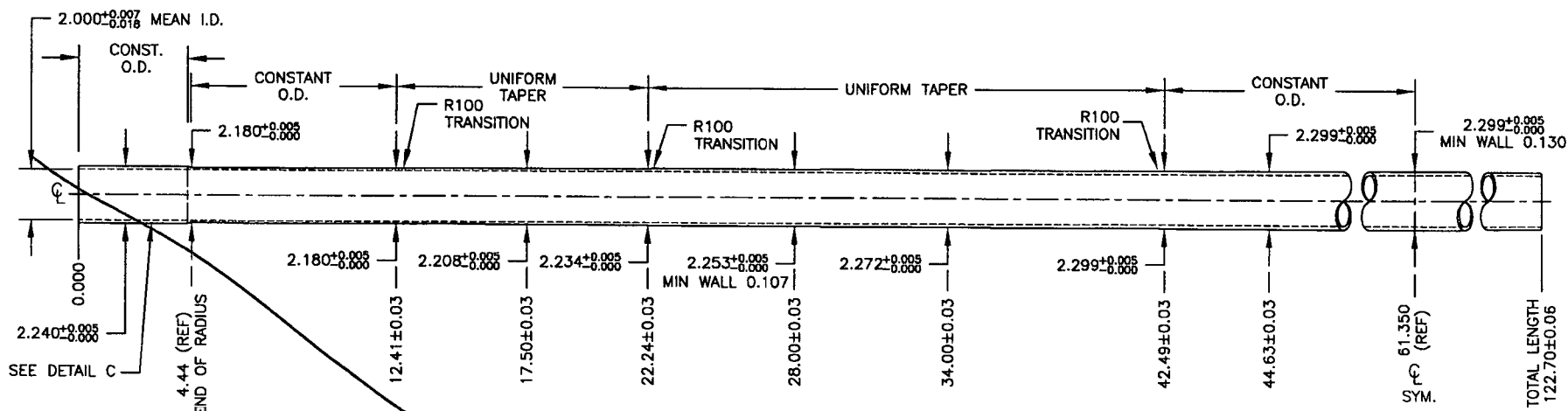


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DATE 06.08.14		TITLE CROSSTUBE (AS 350/355 HI AFT)		SCALE 1:8	

see  
REV D  
07.02.14

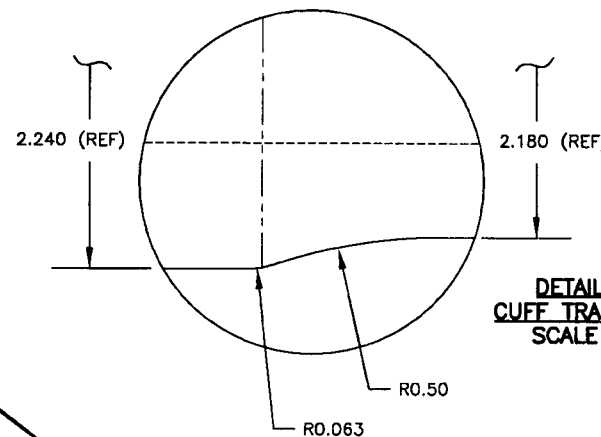
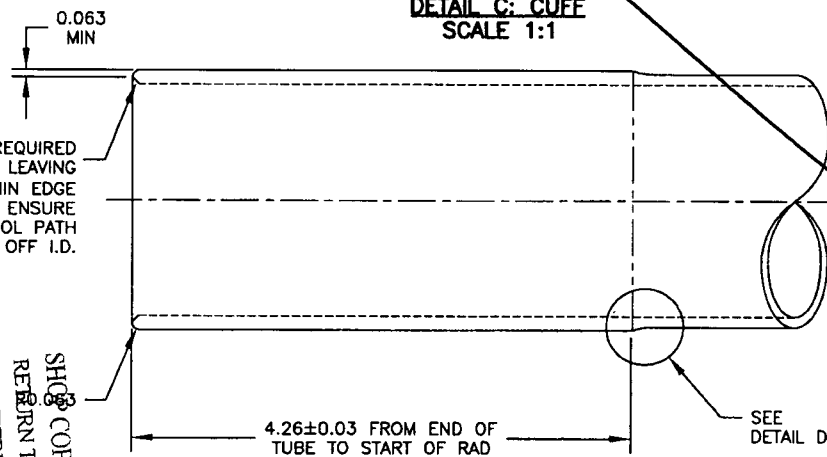


# D350-748-241 MACHINING DETAIL

RELEASED

06.08.15

## DETAIL C: CUFF SCALE 1:1



## DETAIL D: CUFF TRANSITION SCALE 9:1

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		DATE		TITLE CROSSTUBE (AS 350/355 HI. AFT)	SCALE 1:4
		06.08.14			

UNDER REVIEW

CHAMFER AS REQUIRED FOR TOOLING LEAVING 0.062 (REF) MIN EDGE DISTANCE. ENSURE CHAMFER TOOL PATH RUNS OFF I.D.

WORK ORDER NO. 287744  
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE

Handwritten notes: 'See', 'Rad', '06.08.14'





<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 28774A
<b>Description:</b> Crosstube Assembly	<b>Part Number:</b> D350748241
<b>Inspection Dwg:</b> D350-748-24 Rev: C	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	2.240	+0.005 -0.000	2.245	✓			
	2.180	+0.005 -0.000	2.184	✓			
	2.208	+0.005 -0.000	2.213	✓			
	2.234	+0.005 -0.000	2.238	✓			
	2.253	+0.005 -0.000	2.257	✓			
	2.272	+0.005 -0.000	2.276	✓			
	2.299	+0.005 -0.000	2.302	✓			
	.063	+0.010	.063	✓			
	R.50	+0.010	.50	✓			
	4.26	+0.030	4.26	✓			
	122.70	+0.060	122.70	✓			
SIDE B	2.240	+0.005 -0.000	2.244	✓			
	2.180	+0.005 -0.000	2.184	✓			
	2.208	+0.005 -0.000	2.212	✓			
	2.234	+0.005 -0.000	2.238	✓			
	2.253	+0.005 -0.000	2.257	✓			
	2.272	+0.005 -0.000	2.276	✓			
	2.299	+0.005 -0.000	2.303	✓			
	.063	+0.010	.063	✓			
	R.50	+0.010	.50	✓			
	4.26	+0.030	4.26	✓			

<b>Measured by:</b> MS	<b>Audited by:</b> BG	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 6/10/06	<b>Date:</b> 06.10.08	<b>Date:</b>	N/A

<b>Rev</b>	<b>Date</b>	<b>Change</b>	<b>Revised by</b>	<b>Approved</b>
A		New Issue	KJ/JLM	





**VAC AERO**  
INTERNATIONAL INC.

# PACKING SLIP

OAK 80520-1



HEAD OFFICE  
1371 SPEERS ROAD, OAKVILLE, ONTARIO  
CANADA L6L 2X5  
TEL: (905) 827-4171 FAX: (905) 827-7489



QUEBEC DIVISION  
7450 RUE VÉRITÉ STREET, ST. LAURENT, QUÉBEC  
CANADA H4S 1C5  
TEL: (514) 334-4240 FAX: (514) 334-6269

GST No.: R105468102

11/27/2006

MM / DD / YYYY

PAGE: 1

1DAR01

BILL TO: DART AEROSPACE LTD.  
1270 ABERDEEN ST.  
HAWKESBURY, ON

SHIP TO: DART AEROSPACE LTD.  
1270 ABERDEEN ST.  
HAWKESBURY, ON

K6A 1K7

K6A 1K7

DATE SHIPPED	SHIP VIA	F.O.B.
11/27/2006		ORIGIN
CUSTOMER P/O No.	JOB No.	TERMS
PO00002263 ✓		COD

LN	PART NO	DESCRIPTION	UOM	QTY ORDERED	QTY SHIPPED	B/O QTY
01	D350-CROSS TUBES		EA	8	8	0
		Process Specifications: Procedure: 4353 HEAT TREATED TO 180-200 KSI PER AMS 2759-1C 100% HARDNESS TESTED PER ASTM E-18 HRC 40-43 MATERIAL: 4130 SANDBLASTED PARTS				
		1 PIECE D350748141 B28771 1 PIECE D350748141 B28770 1 PIECE D350748141 B28772 1 PIECE D350748141 B28773 1 PIECE D350748241 B28776 1 PIECE D350748241 B28777 1 PIECE D350748241 B28775 1 PIECE D350748241 B28774				
02	MC	MINIMUM CHARGE		1	1	0

No claims for shortage in weight or count will be entertained, unless presented within 5 working days after receipt of materials by customer.



VACUUM BRAZING · HEAT TREATING · SPECIAL PROCESSING · FURNACE EQUIPMENT  
TURBINE COMPONENT OVERHAUL · PLASMA AND OTHER COATINGS



HEAT  
TREATING



**VAC AERO**  
INTERNATIONAL INC.

**RELEASE NOTE**

GST No.: R105468102

OAK 80520-1



HEAD OFFICE  
1371 SPEERS ROAD, OAKVILLE, ONTARIO  
CANADA L6L 2X5  
TEL: (905) 827-4171 FAX: (905) 827-7489



2009 WYECROFT ROAD, UNIT B  
OAKVILLE, ONTARIO  
CANADA L6L 6J4  
TEL: (905) 827-7377 FAX: (905) 827-1380



QUEBEC DIVISION  
7450 RUE VÉRITÉ STREET, ST. LAURENT, QUÉBEC  
CANADA H4S 1C5  
TEL: (514) 334-4240 FAX: (514) 334-6269

11/27/2006

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PAGE: 1

1DAR01

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1270 ABERDEEN ST.  
HAWKESBURY, ON

K6A 1K7

K6A 1K7

DATE SHIPPED	SHIP VIA	F.O.B.
11/27/2006		ORIGIN
CUSTOMER P/O No.	JOB No.	TERMS
PO00002263 ✓		COD

PART No.	DESCRIPTION	UOM	QTY ORD	QTY SHPD	TEST RESULTS
D350-CROSS TUBES		EA	8	8	
<p>Process Specifications: Procedure: 4353 HEAT TREATED TO 180-200 KSI PER AMS 2759-1C 100% HARDNESS TESTED PER ASTM E-18 HRC 40-43 MATERIAL: 4130 SANDBLASTED PARTS</p> <p>100% HARDNESS TESTED 8 PCS → 42/43 HRC</p> <p>1 PIECE D350748141 B28771 1 PIECE D350748141 B28770 1 PIECE D350748141 B28772 1 PIECE D350748141 B28773 1 PIECE D350748241 B28776 1 PIECE D350748241 B28777 1 PIECE D350748241 B28775 1 PIECE D350748241 B28774 ✓</p>					

I hereby certify that the material covered by this release note has been inspected and tested and conforms to all specifications relevant thereto in accordance with the conditions of the contract / or purchase order.

ON BEHALF OF VAC AERO INTERNATIONAL INC.

Authorized Q.C. Inspector



VACUUM BRAZING · HEAT TREATING · SPECIAL PROCESSING · FURNACE EQUIPMENT  
TURBINE COMPONENT OVERHAUL · PLASMA AND OTHER COATINGS



HEAT  
TREATING

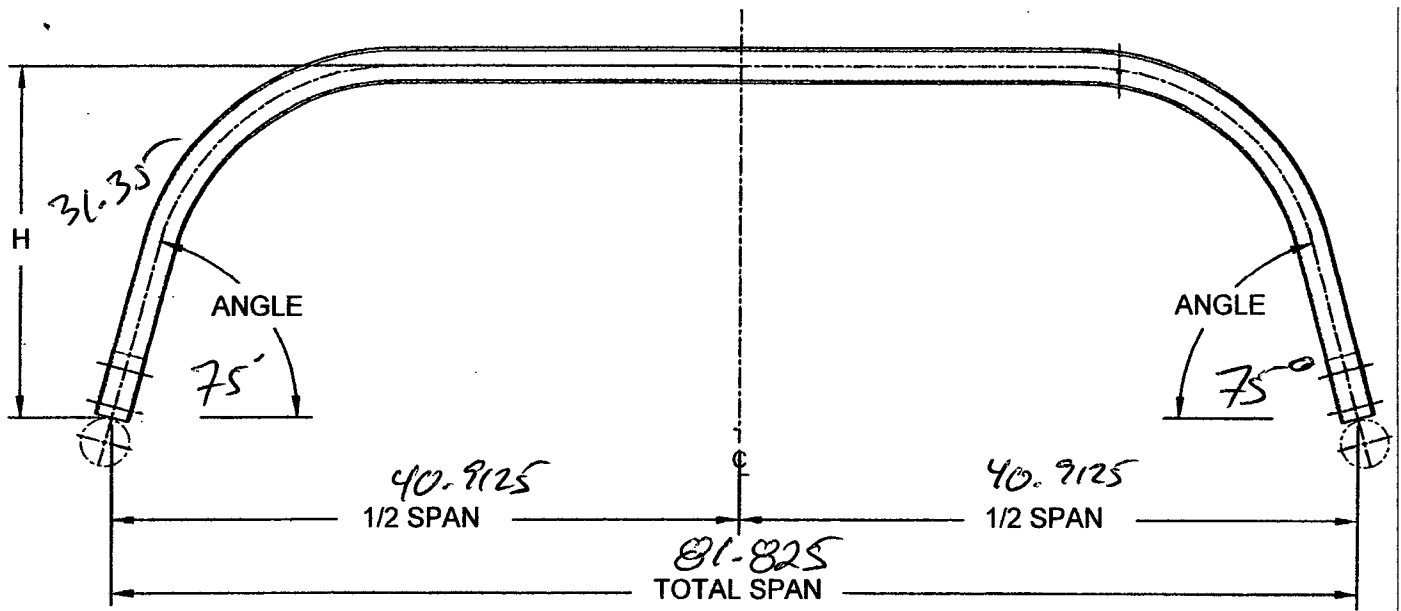
DART AEROSPACE  
1270 Aberdeen Str.  
Hawkesbury, ON  
K6A 1K7

N° DE COMMANDE - ORDER NO.		DÉP - DEPT.	DATE 06-10-17
VENDU À - SOLD TO		EXPÉDIÉ À - SHIP TO VAC AERO 1371 Speers Rd	
ADRESSE - ADDRESS		ADRESSE - ADDRESS Cokville, ON L6L 2X5	

DATE D'EXPÉDITION - SHIPPING DATE	VIA	CONDITIONS - TERMS	N° D'ENR. DE TAXE - TAX REG. NO.	VENDEUR - SALESPERSON
				905-827-4171 ANIMESH
		1 D350-748-141 B28771A		
		<del>1 D350-748-141 B28770A</del>		
		1 D350-748-141 B28773A		
		1 D350-748-141 B28772A		
		1 D350-748-241 B28776A		
		1 D350-748-241 B28777A		
		1 D350-748-241 B28775A		
		1 D350-748-241 B28774A		
Heat treat to min. 180 Ksi				
Sand blast after heat treat				
Certificate of conformity req'd with return				
Return via Epic collect				
acct # 4300450343				
TPS/GST				
TVP/PST				
274726		SIGNATURE	N° LIC. - LIC. NO.	TOTAL



# Crosstube Bend Dimension Sheet



PART NUMBER: 350-748-241

BATCH NUMBER: 20774

DRAWING: -241 REVISION: C

H: 31.35 }  $\pm .130$

1/2 SPAN: 40.9

TOTAL SPAN: 81.8

ANGLE: 75 $\pm$ 2<sub>-0</sub>

QC 15: [Signature]

DATE: 00-12-21

QTY: 1



**DART****RELEASED**06.10.31 *HH*

DESIGN <i>qp</i>	DRAWN BY <i>qp</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>HH</i>	APPROVED <i>HH</i>	DRAWING NO. D350-748-241	REV. D SHEET 1 OF 3
DATE 06.10.31		TITLE CROSSTUBE (AS 350/355 HI AFT)	SCALE NTS
A	06.03.31	NEW ISSUE	
B	06.06.30	ADD D6018-125 & PRIME AND PAINT	
C	06.08.14	ADD CAD PLATING	
D	06.10.31	MAG. PARTICLE AND CAD PLATE AS MFD.	

QTY	P/N	DESCRIPTION
X	D350-748-241	CROSSTUBE ASSEMBLY (AS 350/355 HI AFT)
1	D6018-125	CROSSTUBE (OR D6015-125)
2	D3502-1	SUPPORT
2	D2856-400-710	ABRASION STRIP
1	AELS-1032-225	INSERT
1	AN960JD10	WASHER
2	MS21920-20	CLAMP (PER DART SPEC. M-MS21920-20)
1	MS27039-1-10	SCREW

**D350-748-141 CROSSTUBE:**

- 1) MATERIAL: MANUFACTURED FROM D6018-125 OR D6015-125  
FINISHED LENGTH = 122.70±0.06
- 2) MACHINE PER MACHINING DETAIL ON PAGE 3. BLEND OUT ALL EDGES FROM MACHINING LONGITUDINALLY, TRANSITIONS SHOULD BE SMOOTH. NOTE: ALL HOLES ARE DRILLED AFTER BENDING.
- 3) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 4) BEND PROGRESSIVELY WITH A MINIMUM OF 7 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 5) HEAT TREAT TO MIN. 180 KSI PER MIL-T-6736 OR AMS 2759-1C AFTER TURNING
- 6) FINISH: MAGNETIC PARTICLE INSPECT PER DART QSI 038 4.2  
CADMIUM PLATE PER AMS-QQ-P-416B, CLASS 1, TYPE II  
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2  
PAINT OUTSIDE PER DART QSI 005 4.2
- 7) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE. WHEN DRILLING HOLES EXTREME CARE MUST BE TAKEN AND CAREFUL DEBURRING PERFORMED TO ENSURE A CLEAN HOLE WITH NO CRACKING/CHIPPING/GROOVES.
- 8) INSTALL D2856-400-710 ABRASION STRIP WITH A GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D3502-1 SUPPORT, PER QSI 035.
- 9) TORQUE MS21920-20 CLAMPS 60 TO 80 IN-LB
- 10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 11) ALL DIMENSIONS ARE IN INCHES
- 12) PART IS SYMMETRIC ABOUT CENTERLINE EXCEPT FOR Ø0.297 HOLE.

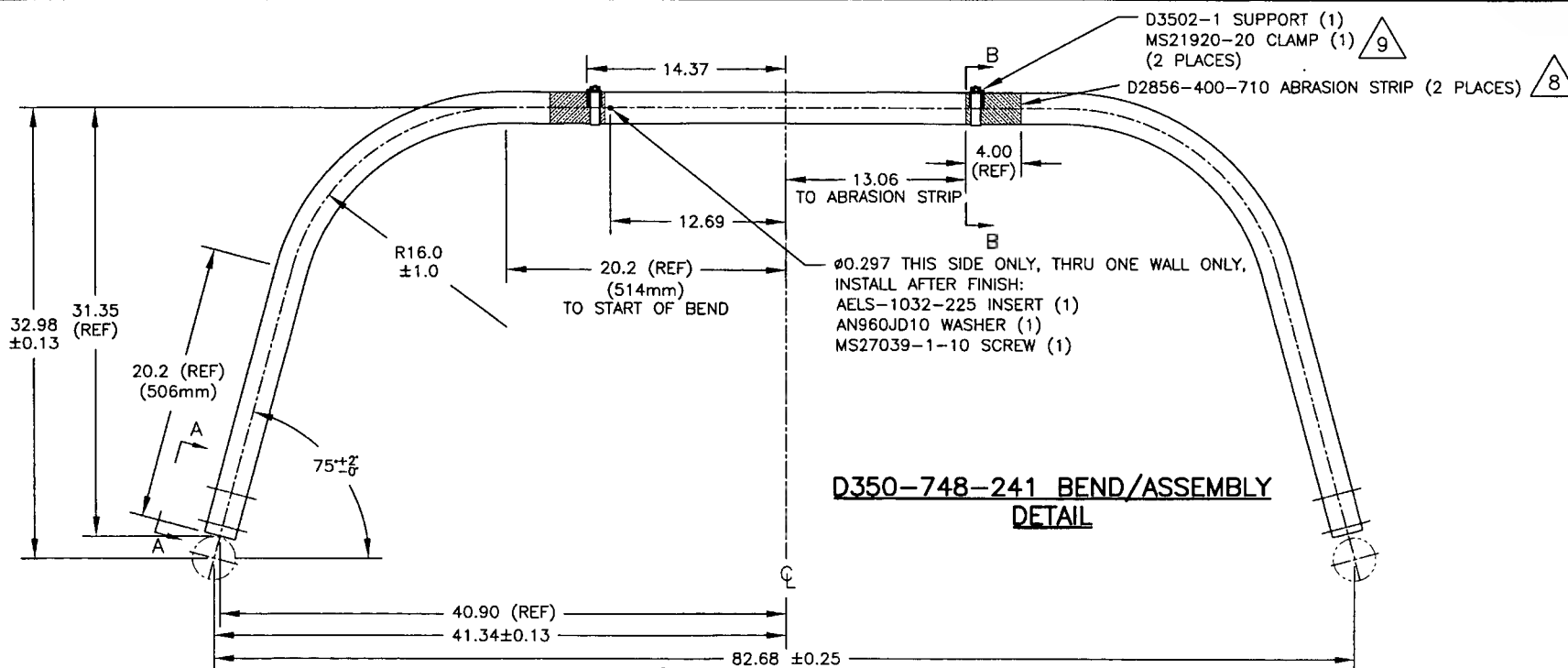
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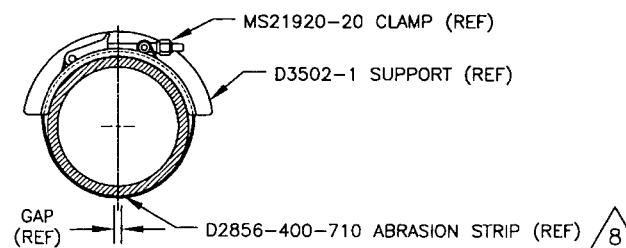
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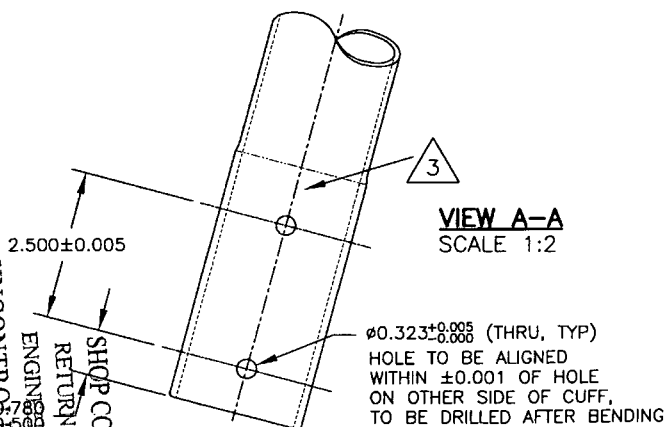


**D350-748-241 BEND/ASSEMBLY  
DETAIL**

**SECTION B-B  
SCALE 1:2**



**VIEW A-A  
SCALE 1:2**



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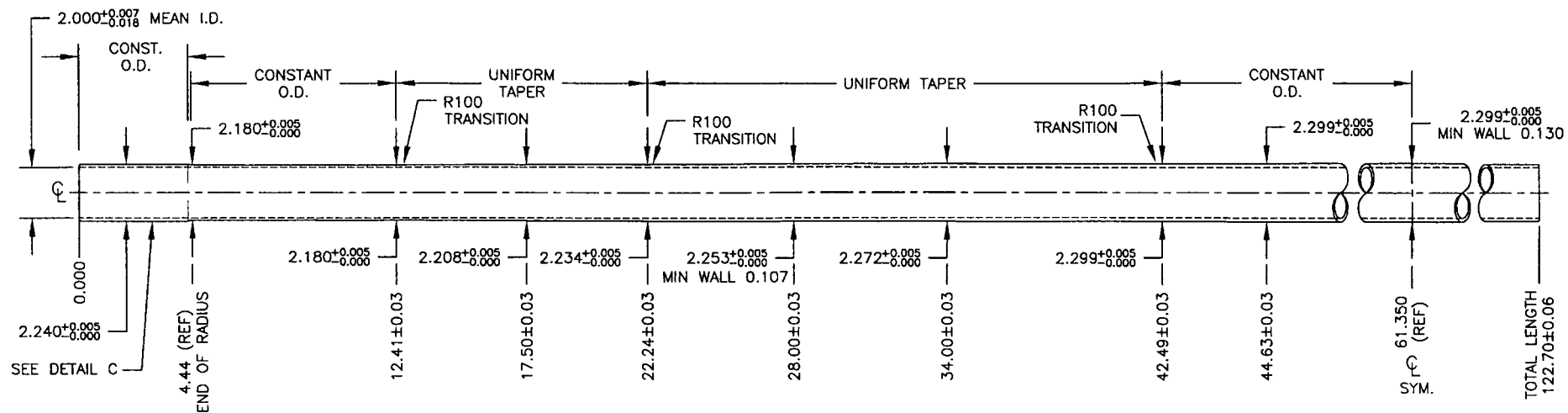
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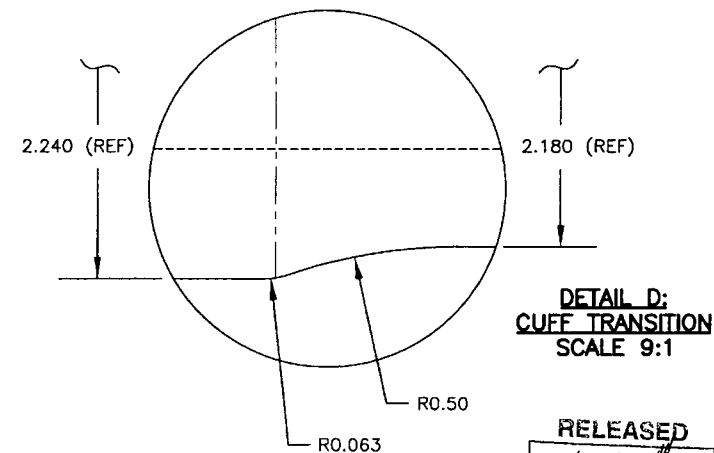
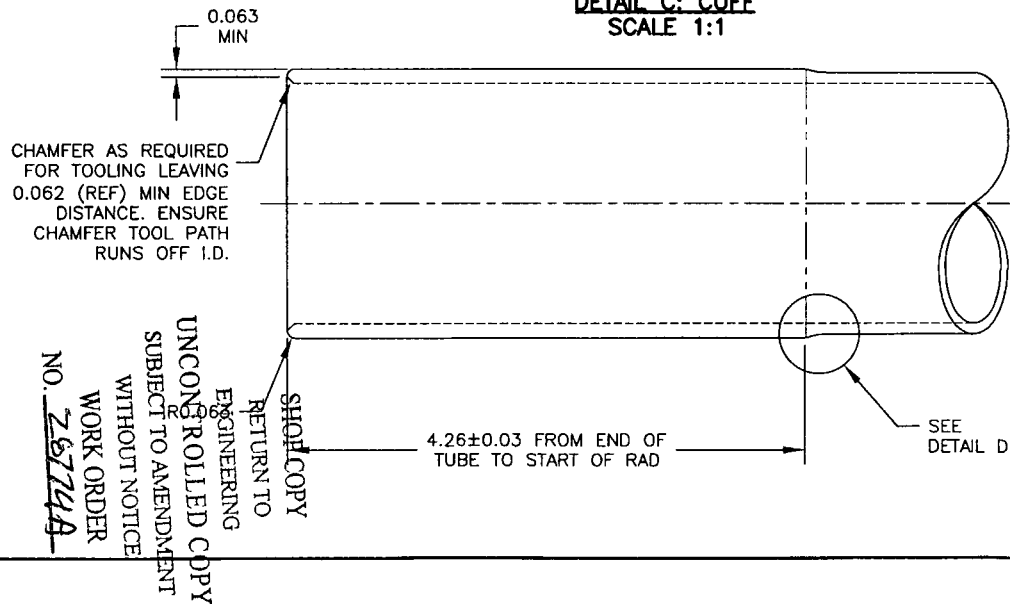
DESIGN qp	DRAWN BY qp	<b>DART</b> DART AEROSPACE LTD. HAMPSHIRE, ONTARIO, CANADA	REV. D
CHECKED #	APPROVED #	DRAWING NO. D350-748-241	SHEET 2 OF 3
DATE 06.10.31	TITLE CROSSTUBE (AS 350/355 HI AFT)	SCALE 1:8	

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### D350-748-241 MACHINING DETAIL

**DETAIL C: CUFF**  
SCALE 1:1



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CHECKED #	APPROVED #	DRAWING NO. D350-748-241	REV. D SHEET 3 OF 3
DATE 06.10.31	TITLE CROSSTUBE (AS 350/355 HI AFT)	SCALE 1:4	





# Southwest United Industries, Inc.

SOUTHWEST UNITED INDUSTRIES, INC.  
422 S. St. Louis Tulsa, OK 74120

Page 1 of 2

## CERTIFICATION

DART AEROSPACE LTD

Certification #: 23920

Certification Date: 03/26/2007

Qty	Part Number/Description	Job-No/Order-No/Ctl-No
1	D350-748-141 CROSSTUBE	48090 PO00003206 B28459
1	D350-748-141 CROSSTUBE	48329 PO00003206 B29757
1	D350-748-141 CROSSTUBE	48330 PO00003206 B28773
1	D350-748-141 CROSSTUBE	48331 PO00003206 B29760
1	D350-748-141 CROSSTUBE	48332 PO00003206 B28776
1	D350-748-141 CROSSTUBE	48333 PO00003206 B28775
1	D350-748-141 CROSSTUBE	48334 PO00003206 B28774

1. Stress relieve at 350-400F for 4 hours minimum
2. Cadmium plate per AMS-QQ-P-416B, Type II, Class 1 (QQ-P-416, Type II, Class 1)
3. Embrittlement relieve within 4 hours of plating at 350-400F for 8 hours minimum
4. Magnetic particle inspect per ASTM E 1444-05. No linear indications/cracks allowed.

Qty Ins: 7    Qty Rej: 0    Qty Acc: 7

5. Inspect

FAA Repair Station CN2R748K

Subject to Southwest United Industries, Inc. Standard Terms and Conditions available for review at [www.swunited.com](http://www.swunited.com)





## Southwest United Industries, Inc.

SOUTHWEST UNITED INDUSTRIES, INC.  
422 S. St. Louis Tulsa, OK 74120

Page 2 of 2

### CERTIFICATION

We certify that the parts listed above have been processed in accordance with the requirements and specifications of the above referenced purchase order. Documentation is on file and available for review.

Certification By: 

FAIN, MARK



FAA Repair Station CN2R748K

Subject to Southwest United Industries, Inc. Standard Terms and Conditions available for review at [www.swunited.com](http://www.swunited.com)







## Southwest United Industries, Inc.

SOUTHWEST UNITED INDUSTRIES, INC.  
422 S. St. Louis Tulsa, OK 74120

Page 1 of 1

### PACKING LIST

DART AEROSPACE LTD  
1270 ABERDEEN STREET  
HAWKESBURY, ON K6A 1K7  
CANADA

Ship ID: 18869  
Ship Date: 03/26/2007  
Terms: C.O.D.

Certification #: 23920

Certification Date:

1 D350-748-141  
CROSSTUBE

Ref-No: B28459  
Job-No: 48090  
P/O #: PO00003206

1 D350-748-141  
CROSSTUBE

Ref-No: B29757  
Job-No: 48329  
P/O #: PO00003206

1 D350-748-141  
CROSSTUBE

Ref-No: B28773  
Job-No: 48330  
P/O #: PO00003206

1 D350-748-141  
CROSSTUBE

Ref-No: B29760  
Job-No: 48331  
P/O #: PO00003206

1 D350-748-141  
CROSSTUBE

Ref-No: B28776  
Job-No: 48332  
P/O #: PO00003206

1 D350-748-141  
CROSSTUBE

Ref-No: B28775  
Job-No: 48333  
P/O #: PO00003206

1 D350-748-141  
CROSSTUBE

Ref-No: B28774  
Job-No: 48334  
P/O #: PO00003206

# OF JOBS ON 23920:

7

SHIPPED QTY FOR 23920:

7

Tracking #: SCX K  
Ship Via: OTHERS

FAA Repair Station CN2R748K

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